Date:

Thursday, 10/08/2006 10:04:06 AM ,

User:

Linda Lacelle

Process Sheet

Drawing Name

Customer

: CU-DAR001 Dart Helicopters Services *

: BASKET LID ASSEMBLY

Job Number

: 28140B

Estimate Number

: 10207

P.O. Number

AU:

This Issue

Prsht Rev.

First Issue

: 10/08/2006

S.O. No. : NA

: NC

: NIA

Type : LARGE FAB ASSY

: 27131

Previous Run Written By

Checked & Approved By

Comment

: Est Rev:I

Removed D2989-041

05-11-03

Material

Due Date

: D2989043 **Part Number**

Drawing Number

: D2989 REV B

. : N/A Project Number **Drawing Revision**

: NIA

: 31/08/2006

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: Hinge

1.0

D31821



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part number

Description Batch

D3182-1

Hinge R 25845

2.0

D34423



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)



Qty Part number

Description Batch

D3442-3

Shim

3.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 8.0000 sf(s)/Unit

Total:

8.0000 sf(s)

Pick:

Qty Part number

Description Batch

Expanded Metal

M101707

4.0

M304TS0750W065

304 SQ Tube.75x.75x.065W

15sf M304EX0.75-16F

Comment: Qty.: 17.6400 f(s)/Unit Total: 17.6400 f(s) 3/4" x 3/4" x 0.063" wall 304/316-\$\$tubing.

Batch MIDISGI 25 K"

M101359

Page 1

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		•								

Part No):	PAR #:	Fault Category:			NCR: Yes (N	DQA:	Đ Date: Ը	1 <u>2/05/3</u> 0
						QA: N/C	Closed:	Date: _	
NCR:			WORK ORDE	R NON-CONFO	ORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			3	Verification	Annaval	Annessal
DATE	STEP	STEP Description of NC Section A	Initial Action Description Chief Eng Chief Eng		ption	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

	STEP	Description of NC Section A	1		Varification	Annearal	Anneoval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				-				
				•				
			·					

NOTE: Date & initial all entries

Thursday, 10/08/2006 10:04:06 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 28140B

Seq. #:

Job Number:

Machine Or Operation:

Description:

Part Number: D2989043

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989 Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

106/08/16 0

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

6.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION





Comment: DDIMENSIONAL & WELDING INSPECTION

7.0

POWDER COATING

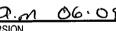
POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005.4.3 & Dwg D2989

8.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

06.08,28.

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



C20008129

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHAN	GES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-								
Part No:		PAR #:	NCR: Yes No DQA: Date:						
					QA: I	N/C Close	d:	_ Date: _	
NCR:		\	WORK ORDE	R NON-CONFORM	IANCE (NCI	₹)			
DATE	STEP	Description of NC	Section B		cation	Approval	Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
			·		; *				

NOTE: Date & initial all entries